

Tuesday, April 21, 2015 1:45:38 PM

Page 1

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Work Order ID 131678

131678

Page 2

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Item ID: D5953 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle
Start Date: 4/20/15 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				4	0	15-8-26	DOC
130	HandFinish	0.00							
Hand Finishing	Memo								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4	0	15-8-27	DAS 38 9-89
140	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 2:00 OVEN TEMPERATURE:								
	FINISH TIME: 2:30								
150	QC3- Inspect Part Finish	0.00				(4)			DAS 38 9-89
150	QC	0.00							
Quality Control	Memo								

AUG 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 131678

131678

Page 3

Tuesday, April 21, 2015 1:45:38 PM

Item ID: D5953 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Saddle

Start Date: 4/20/15 Start Qty: 4.00 *4* Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>st 399</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

20150831

SH

15/8/31

Y S M B

AUG 31 2015

DQA: _____ Date: _____



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OTHER : ☐																									

Picklist Print

Tuesday, April 21, 2015 1:45:38 PM

Page 1

Work Order ID: 131678

131678

Parent Item: D5953

D5953

Parent Item Name: Saddle

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:f ecn 826 06.12.06 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	27.0000	1	4			
D6101-007									**				
Saddle Billet													

DAS
44
9-89 15/06/20

Location	Loc Qty	Loc Code
MAT041	19	
127646	1	
131095	18	
MAT044	8	
116083	1	
120494	7	

132722

4

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
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Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____						

DART AEROSPACE LTD		Work Order:	131678
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.316	.316	.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.316	.316	.316		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.504	.503	.503	.504		
N	1.615	1.635		1.632	1.628	1.629	1.629		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.256	2.256	2.256	2.256		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.497	.497	.497	.497		
T	1.375	1.395		1.3825	1.3825	1.382	1.381		
U	2.000	2.020		2.003	2.0045	2.0045	2.0045		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

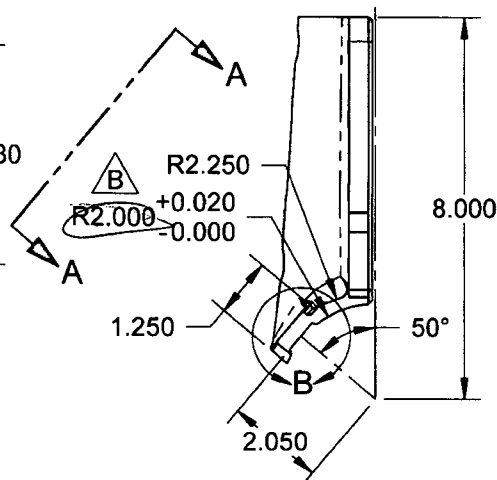
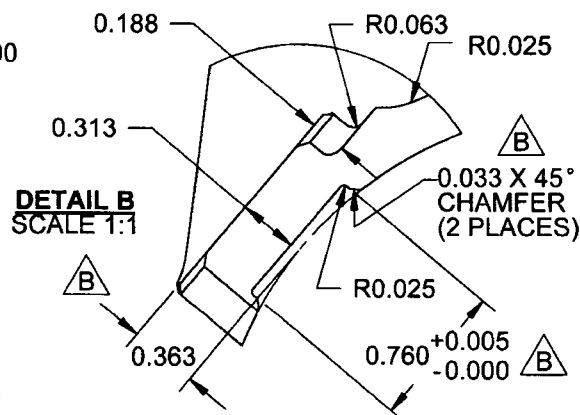
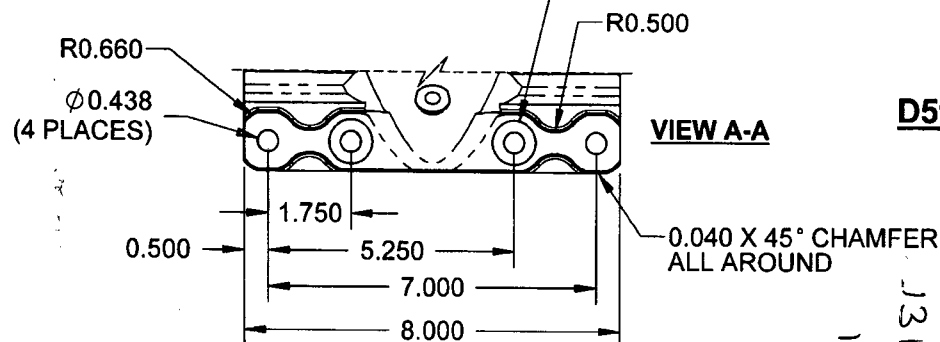
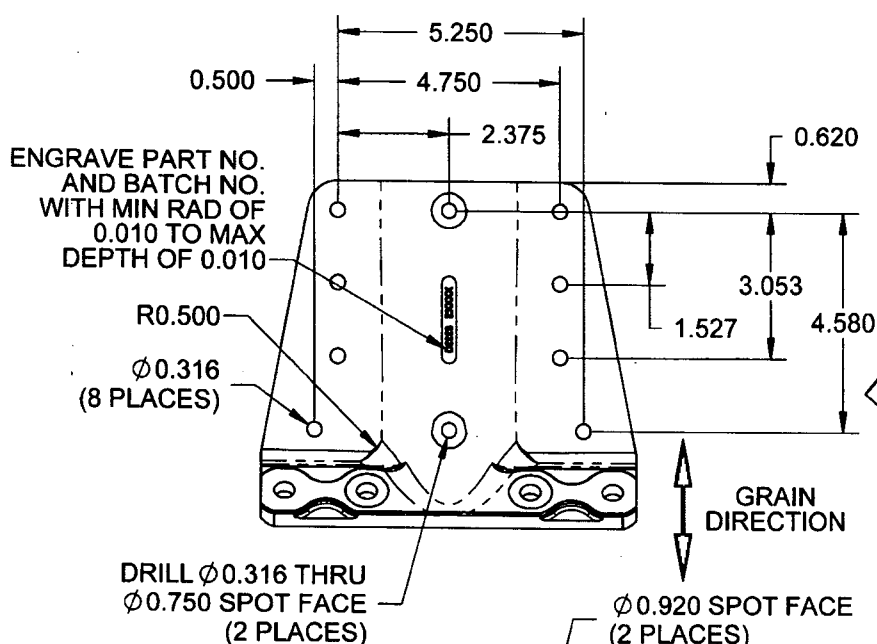
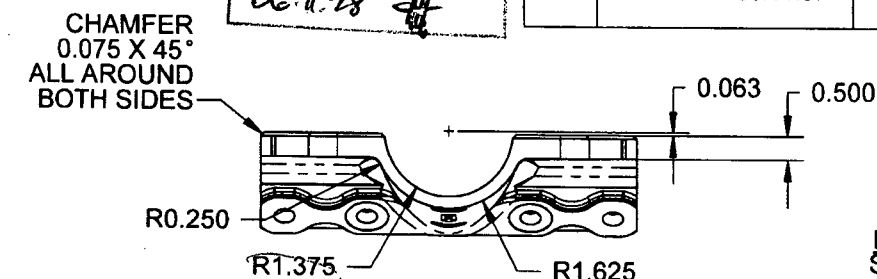
Measured by:	44
Date:	15/06/20

Audited by:	J-FC	DAS
Date:	2015-06-23	15/08/25 08 9-89

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	



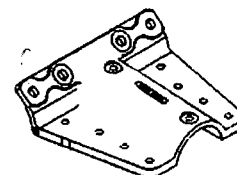
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



D5953 INNER FWD SADDLE

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW SCALE 1:8

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Part Number: D5953	Rev: B	- Page 1 -
Description: INNER FWD SADDLE	Inspection Dwg: D5953	Work Order: 131678

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
D1	0.075	+0.010/-0.010	0.080	0.080	0.076	0.075	
D2	0.250	+0.010/-0.010	0.250	0.250	0.250	0.250	
3	1.375	+0.010/-0.010	1.379	1.379	1.379	1.379	
D4	1.625	+0.010/-0.010	1.625	1.620	1.625	1.625	
5	0.063	+0.010/-0.010	0.059	0.059	0.058	0.059	
6	0.500	+0.010/-0.010	0.502	0.502	0.501	0.501	
7	0.188	+0.010/-0.010	0.189	0.190	0.191	0.188	
D8	0.313	+0.010/-0.010	0.310	0.309	0.310	0.310	
9	0.363	+0.010/-0.010	0.365	0.365	0.363	0.363	
D10	0.760	+0.005/0.000	0.760	0.760	0.760	0.760	
D11	0.033	+0.010/-0.010	0.033	0.033	0.033	0.033	
12	0.063	+0.010/-0.010	0.063	0.061	0.062	0.062	
13	8.000	+0.010/-0.010	8.000	8.000	8.001	7.999	
Ang14	50.000	+0.500/-0.500	49.981	50.001	50.013	50.015	
15	2.050	+0.005/0.000	2.054	2.051	2.051	2.050	
D16	1.250	+0.010/-0.010	1.253	1.253	1.253	1.255	
17	2.000	+0.010/-0.010	1.999	1.998	2.000	1.998	
D18	2.250	+0.010/-0.010	2.252	2.250	2.250	2.250	
19	0.500	+0.010/-0.010	0.501	0.500	0.504	0.501	
20	5.250	+0.005/-0.005	5.247	5.247	5.245	5.247	
21	4.750	+0.005/-0.005	4.748	4.749	4.749	4.749	
22	2.375	+0.005/-0.005	2.376	2.376	2.376	2.376	
23	0.620	+0.010/-0.010	0.623	0.622	0.621	0.621	
24	1.527	+0.005/-0.005	1.527	1.526	1.528	1.527	
25	3.053	+0.005/-0.005	3.053	3.054	3.055	3.054	
26	4.580	+0.005/-0.005	4.581	4.580	4.585	4.582	
27	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	
D28	0.750	+0.010/-0.010	0.750	0.750	0.750	0.750	
29	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	
30	0.438	+0.005/0.000	0.438	0.438	0.438	0.438	
31	0.500	+0.010/-0.010	0.496	0.495	0.494	0.495	

Measured by:
Mathieu Lamarche

Date:
2015-8-25

Audited by:

D.A

DAS
08
9-89

Date:

15/08/25



Part Number: D5953	Rev: B	- Page 2 -
Description: INNER FWD SADDLE	Inspection Dwg: D5953	Work Order: 131678

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
32	1.750	+0.005/-0.005	1.749	1.750	1.750	1.750	
33	5.250	+0.005/-0.005	5.250	5.251	5.251	5.251	
34	7.000	+0.005/-0.005	7.000	7.000	7.001	7.001	
35	8.000	+0.010/-0.010	8.001	8.001	8.001	8.001	
D36	0.040	+0.010/-0.010	0.040	0.040	0.040	0.040	

Measured by:
Mathieu Lamarche

Date:
2015-8-25

Audited by:

Date:

15/08/25

DAS
09
9-89